

Date: Wednesday, 4/4/2007 9:03:42 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 31610					
Estimate Number	: 10310					
P.O. Number	: N/A		Part Number	: D26175		
This Issue	: 4/4/2007	S.O. No. : N/A	Drawing Number	: D2617 REV D2		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D2		
Previous Run	: 31033		Material	: N/A		
Written By			Due Date	: 4/15/2007 Qty: 30 Um: Each		
Checked & Approved By						
Comment	: Est H 04.07.14 Reformat; added step 5 KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W	
Comment: Qty.: 0.0205 f(s)/Unit Total : 0.6143 f(s) 6061-T6 Round Bar 1.5" Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058) Batch <u>1104007</u> <span style="float: right;">SF 07/04/17</span>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
Comment: HARDINGE CNC LATHE SMALL  1-Machine as per Folio FA438 and Dwg D2617  2-Deburr <span style="float: right;">SF 07/04/17 (35)</span>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SF 07/04/17</span>			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <span style="float: right;">SF 07.04.17</span>			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <span style="float: right;">FL 07/04/23 (35)</span>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/24  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 31610

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

*E. Bottay/23*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*E. Bottay/23 (35)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



*(35)*

Comment: FINAL INSPECTION/W/O RELEASE

*E. Bottay/24*

Job Completion



*4/4/24*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31610
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617	Rev: D2	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

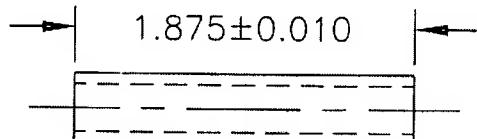
Measured by:	<i>J.S.</i>	Audited by:		Prototype Approval:	N/A
Date:	<i>07/04/17</i>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	<i>[Signature]</i>
B	06.03.08	Dwg Rev change	KJ/JLM	<i>[Signature]</i>

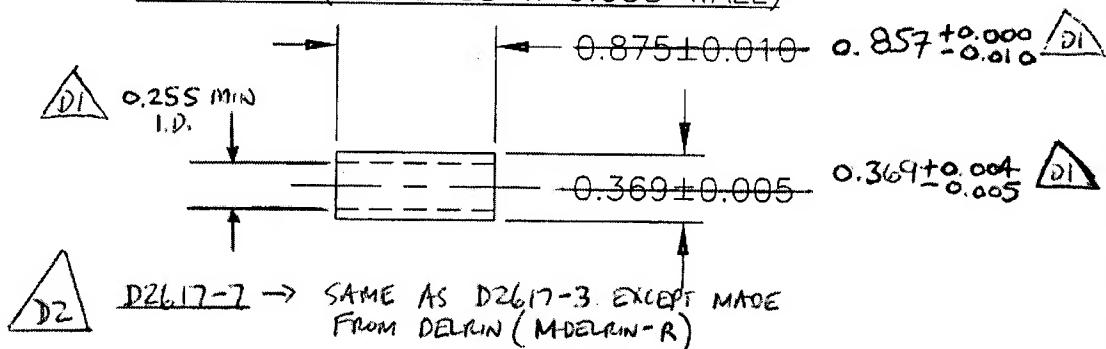


DESIGN	BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04		TITLE BUSHING		SCALE 1:1
D2   04.09.10 <i>#</i> / 07   ADD D2617-7	A	96.10.08	NEW ISSUE	
	B	97.05.08	.875 WAS 1.125	
	C	97.06.04	0.369 DIA WAS 0.375	
	D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE	
	DI <i>IP-#</i> 04.07.12	CORRECT TOLERANCE (NCR 779)		

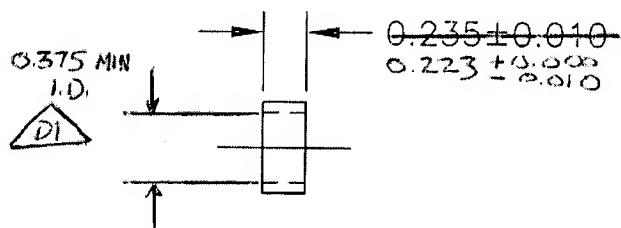
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31610

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES